



Dart Aerospace Ltd.
1270 Aberdeen St
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D4436-043
Job Sheet 203079



Part No: D4436-043

Job Qty: 6 pcs

Part Name: Aft Outboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP REV:B 12.01.24 PER DWG REV.A DD
VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		12/12/19	0.17 0.91	Waterjet - Flow		JRB 12/8/19
110	QC 2	6 pcs		12/12/19	0.00 0.00	QC 2 - 1		
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		
						QC 2 - 8		
						QC 2 - 66		
						QC 2 - 64		

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Container No: S238097



Part: D4436 - 043

Job No: 203079

Serial No/Batch: S238097

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/08/19

Plex 11/8/19 9:27 AM Dart.lajeunesse.marie

120	QC 8	6 pcs	12/12/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	JAB 12/9/19
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	DEC 10 2019 40 9-89
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Small Fab - Brake NC - B4B	6 pcs	12/12/19	0.25 0.52	Small Fab - Brake - 1 - B4B	DAS 30 9-89 DEC 13 2019
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	Small Fab - 2 - B4B	6 pcs	12/12/19	0.00 0.70	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DEC 12 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
150	QC 5	6 pcs	12/12/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS 81 9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	

DEC 17 2019

DAS
30
9-89

DEC 17 2019

					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
180	Small Fab - 3 - B4B	6 pcs	12/12/19	0.00 0.70	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DEC 18 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
185	QC 5	6 pcs	12/12/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS DEC 18 2019 9-89
					QC 5 - 61	
					QC 5 - 81	
190	Powdercoat - 4 Black Sand - B4B	6 pcs	12/12/19	0.00 0.29	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
200	QC 3	6 pcs	12/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	

202 Small Fab - 4 - B4B	6 pcs	12/12/19	0.00 0.70	QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
205 QC 5	6 pcs	12/12/19	0.00 0.00	Small Fab - 4 - B4B	DEC 19 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
210 Packaging 3-1 - Stock - B4B	6 pcs	12/12/19	0.00 0.00	QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS DEC 19 2019 9-89
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	57621 DAS 74 DEC 20 2019 9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	

					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220	QC 21 - SA	6	12/12/19	0.00 0.00	QC 21 - SA - 21	DAS
		pcs			QC 21 - SA - 70	21
					QC 21 - SA - 53	9-55

DEC 20 2019

Part Op **100** - 1-Cut D4436-1 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Bend/Assemble as per dwg)
140 - (Small Fab) C"SINK AS PER DWG
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Chemical Conversion Coat per QSI005 4.1)
170 - (QC7-Inspect Chemical Conversion Coat)
180 - (Small Fab) Assemble as per dwg, do not install rubber seal.
185 - (QC5- Inspect part completeness to step on W/O)
190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: 8:30 M156440. OVEN TEMPERATURE: 900.
FINISH TIME: _____
200 - (QC3- Inspect Part Finish)
202 - (Small Fab) Install rubber seal as per dwg 3M 1300 batch: _____
205 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	DAS 6061-T6 .040 Sheet	9.5400 sf (1.59 ea)	100-Waterjet - Flow - 1	5201169
MS20426AD3-2	30 Rivet	24 Ea (4 ea) 48	180-Small Fab - 3 - B4B	5174201
MS21075L08	9-89 Anchor Nut	12 Ea (2 ea) 24	180-Small Fab - 3 - B4B	8240530
D4441-1	Rubber Seal	8.4480 ft (1.408 ea)	202-Small Fab - 4 - B4B	5092167

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	10	195	0
180-Small Fab - 3 - B4B	MS20426AD3-2	24	18,364	0
	MS21075L08	12	58	0
202-Small Fab - 4 - B4B	D4441-1	8	228	0

Part Specifications

Specifications could not be found.

Plex 11/8/19 9:27 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	203079
Description: Bracket		Part Number:	D4436-1
Inspection Dwg: D4436 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: JAB	Audited by: 40 9-89	Preliminary Approval:
Date: 12/5/19	Date: DEC 10 2019	Date:

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	19.01.22	Revised Dwg revision	MG	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>203079</u> Part No. <u>D 4436-043</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : <u>DEC 13 2019</u>	Sequence #: <u>130</u>	QTY Affected : <u>1 of 12</u>	MRB (QSI042) <u>PD 12-12-19</u>	
Description Work Order Deviation		Disposition		Completed By <u>DAS</u> <u>30</u> <u>9-89</u>
<u>Part moved during bend</u> <u>out of tolerance</u>		<u>Scrap & destroy</u> <u>No replace</u>		Lead hand / Supervisor <u>DAS</u> <u>30</u> <u>9-89</u> <u>DEC 13 2019</u>
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☒ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				

Entered: 2R Date: Dec 31/19



NCR No. 19-7815 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>203079</u> Part No. <u>04436-043</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS					
				Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date : DEC 19 2019		Sequence #: <u>205</u>		QTY Affected : <u>1 of 11</u>			MRB (QSI042)		
Description Work Order Deviation				Disposition			PD 19.12.19		
- parts has a big kink in it was found at final inspection				- scrap no replace			Completed By <u>Se 19-12-19</u>		
							Lead hand / Supervisor DAS 30 9:09		
							QC / QA Coordinator <u>PD 19.12.19</u>		
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY							
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☒ Cracks ☒ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
		Other/Details:							